

Step 17/10

Dart Aerospace Ltd.

Date: Thursday, 10/11/2007 2:54:08 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STRUT	0
Job Number	35119			
Estimate Number	10957			
P.O. Number	N/A	Part Number	D2565205	
This Issue	10/11/2007	S.O. No.	11A	Drawing Number D2565 REV E
Prsht Rev.	NC			Project Number N/A
First Issue	N/A	Type	SMALL /MED FAB	Drawing Revision E
Previous Run	31969			Material N/A
Written By				Due Date 10/17/2007
Checked & Approved By				Qty: 10 Um: Each
Comment	Est: E 01/08.28 Added Powder coat, and added Inspection Levels 3 and 21. SM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 1.8812 f(s)/Unit Total : 9.4059 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049)	Batch No: M105732 SB 07/10/16 (10)
2.0	BRAKE NC	NC BRAKE	
		Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313	SB 07/10/16 (10)
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole as per Dwg D2565 (one end only) Deburr and polish	SAW 07/10/18 (10)
4.0	QC5	INSPECT WORK TO CURRENT STEP	 current on 07/10/18 (10)
		Comment: INSPECT WORK TO CURRENT STEP	on 07/10/18 (10)
5.0	POWDER COATING	POWDER COATING	 10x M-105068 07/10/20
		Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	m-f 07/10/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/01/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 35119

Part Number: D2565205

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*C. Taylor* (10)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST253* (10)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*10/11/07*

Job Completion



*U Oct. 22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

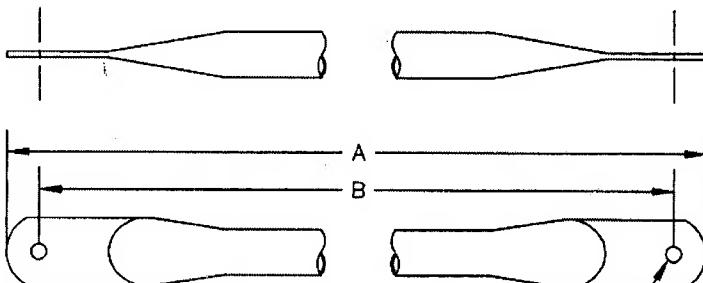
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	D2565	REV. E
				SHEET 1 OF 1
DATE		TITLE	STRUT	SCALE
04.05.05				1:3
A	96.05.03	NEW ISSUE		
B	97.03.15	CORRECT D2565-111 DIM. A		
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)		
D	02.06.05	ADD -3XX PARTS; ADD FINISH		
E	04.05.05	ADD D2565-401-411; RMV ANGLE D		

**RELEASED**  
 04.05.05

 DIA 0.257 TO BE PUNCHED  
 "C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
 (REF. DART SPEC. M304TR0.750W0.049)  
 ENSURE SEAMLESS TUBE IS USED

 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005  
 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) ALL DIMENSIONS ARE IN INCHES

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 WORK ORDER  
 NO. 35719

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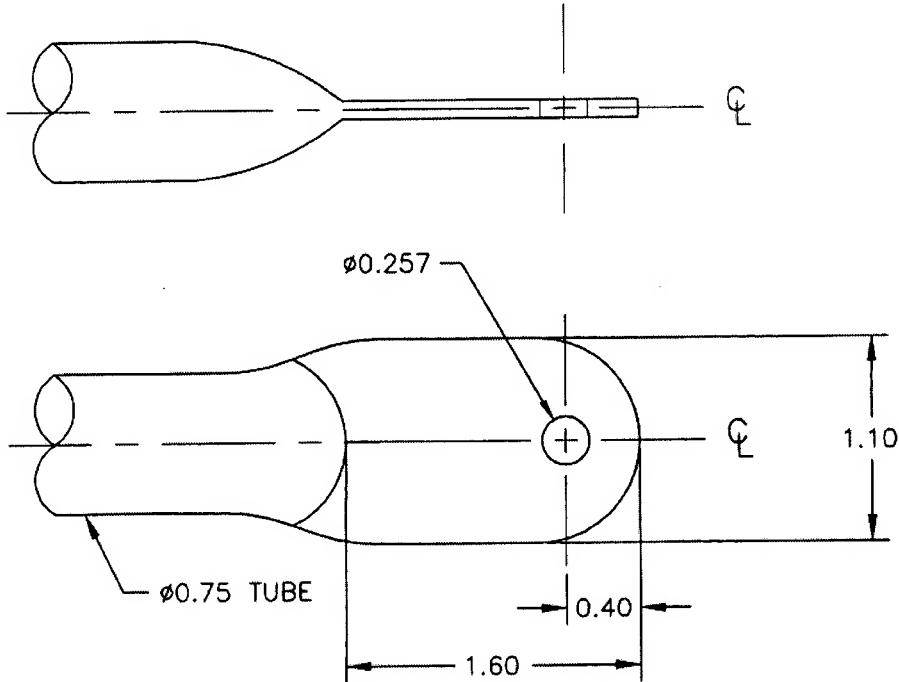
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**DART**

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MJ</i>	APPROVED <i>JF</i>	DRAWING NO. D2638
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL
A	98.04.28	SCALE 1:1
		NEW ISSUE

**RELEASED**  
98/05/05 KE

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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